

Date: Wednesday, 21/01/2009 7:38:27 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LOCKING SLEEVE
Job Number	: 44999		
Estimate Number	: 12062		
P.O. Number	:	Part Number	: PB6743001137
This Issue	: 21/01/2009 S.O. No. :	Drawing Number	: B6743001 PAGE35
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 40023	Material	:
Written By	:	Due Date	: 27/01/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>MF 09-01-21</u>		
Comment	: Est. A 05.08.29 New issue KJ/JLM Est Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 0.1860 f(s)/Unit Total : 1.8596 f(s)

6061T6 TUBE

Turn as per Dwg B67-43001

Dwg Rev: B1Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) Ø1.00 x .065" wall tubing
(M6061T6T1.000W.065)

Identify for B67-43001-137

Batch: M110278

Deburr

07/02/07

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE

1- Turn as per Folio FA

Rev: 1/a & Dwg B67-43001-1Rev: B1

2-Deburr per dwg B67-43001-1

07/02/07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/02/07 (12)
09/02/08 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCKING SLEEVE

Job Number: 44999

Part Number: PB6743001137

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JS

09-02-10

(X12)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask inside sleeve

START TIME:

8:10am

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:40am

JS

09-02-17

AK

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FK 09/02/17

(12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/2/17 (12)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



MK 09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

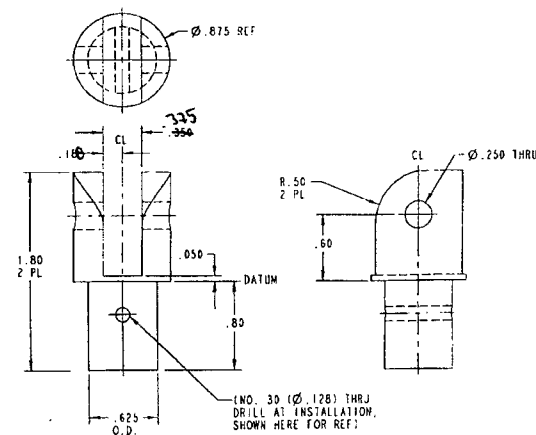
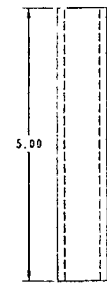
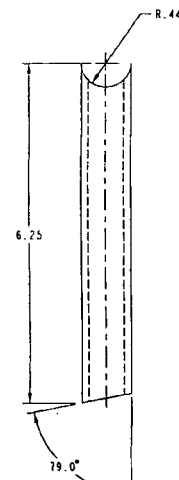
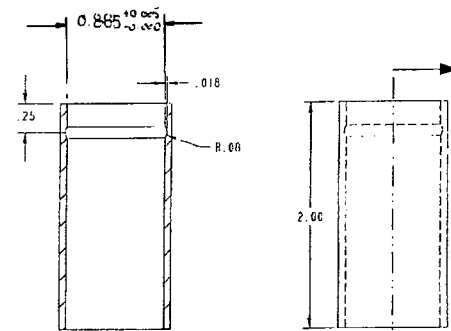
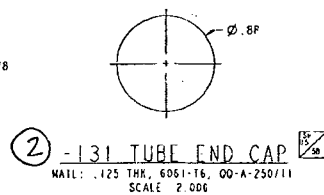
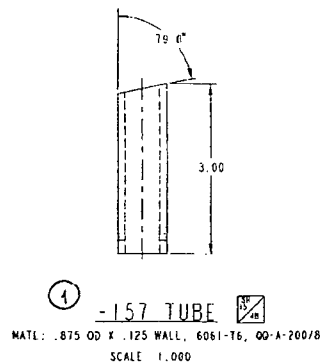
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
06.01.20

44999



PREMIER AVIATION, INC.
8000 Aviation Parkway, Grand Prairie, Texas 75052
D105UV8 867-43001
REV 5A
SHEET 35 OF 45

ORIGINAL